

Work Order ID 54216

December 03, 2009 12:33:39 PM



Page 1

Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 09/12/3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

Draw Nbr	Revision Nbr
D212-664-141	Rev D

100



DOCUMENT CONTROL

0.00

DC

Document Control

Memo

Photocopy bluefile and create labels as per PPP D212-664-101

CHG003

110



Pick Kit

Packaging

0.00

Packaging

Memo

0.00

120



BENDING MACHINE - CROSSTUBES

0.00

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9-12-17	120	-Tube overheat 1" on 1 side -side B	10/02/17 Q51042	- Verify wall thickness w/ultra sonic. Minor abnormalities Found. - Scrap & Destroy (P) RC: Process	10/02/17 Q51042	S 10/02/17	10/02/17 Q51042	S 10/02/17

NOTE: Date & initial all entries

WALL THICKNESS

D-212-664-101
B-54216

Side A

1 - .209

2 - .235

3 - .265

4 - .184

5 - .255

6 - .232

7 - .287

8 - .347

9 - .373

Side B

WB

09-12-09

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

130



Operation
Description

QC15- Crosstube Dimensional Check

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC



Quality Control

140



Crosstubes

0.00

0.00

Memo

Crosstubes

Memo

Crosstubes

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

SCRDP

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Crosstubes Chemical Conversion

0.00

HandFXtube

Hand Finishing Crosstubes

Memo

0.00

Chemical Conversion Coat within 24 hours of bending and drilling

160



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

Scrap

170



Outsource process - NDT per QSI038 4.1

0.00

Outsource2

Outsource process - NDT

Memo

0.00

Liquid Penetrant Inspection as per QSI038
Issue P/O: _____
LPI as per ASTM 1417 Level 2
Attach copy of NDT results to work order

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

180



Packaging

Packaging

Operation
Description

Receive & Inspect for Damage & Mat'l Certs
Packaging

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Inspect for damage & ensure results are as per Dwg D212-664-141

0.00

Scn P/S

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D212-664-101

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Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200



SprayPaint

Operation
DescriptionSpray Painting per QSI005 4.2
SprayPaintSet Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Spray Painting

Memo

0.00

1-Prime inside and outside crosstube as per QSI 005 4.2
2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: _____

Finish Time: _____

PAINT:

Start Time: _____

Finish Time: _____

210



QC

QC14- Inspect Spray Paint

0.00

Quality Control

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval, QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54216

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Item ID: D212-664-101

Accept



Setup Start



Revision ID:

Item Name: Crosstube Fwd

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

220



Crosstubes

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

Crosstubes

Memo

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area
with 41058 wash 'n' wipe
2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs
A/R 6398 Magnobond Batch: _____

230



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

240



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

Scn A6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D212-664-101**Accept****Setup****Start****Revision ID:****Item Name:** Crosstube Fwd**Stop****Start Date:** 12/3/2009 **Start Qty:** 1.00**Cust Item ID:****Required Date:** 12/22/2009 **Req'd Qty:** 1.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID**

250



QC

Quality Control

**Operation
Description**

QC4- 100% Inspect kits for completeness

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

260



Packaging

Packaging

Packaging**Memo**

0.00

0.00

270



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

 MF
 10-2-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54216



Parent Item: D212-664-101RevC



Parent Item Name: Crosstube Fwd

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D212-664- 101TRNRevC		Manufactured	No			110	Each	2.0000	1.0000			

Crosstube Turning Detail



13-54284

MB 02-12-09

Warehouse Location Loc Qty Loc Code

Main Warehouse

D3595-063-450RevA

Manufactured

No

RUBBER CUSHION

FG	2	
53256	1	
53257	1	

Warehouse Location Loc Qty Loc Code

Main Warehouse

RUBBER CUSHION

LG	230	Each	188.9689	4.2105	
----	-----	------	----------	--------	--

Main Warehouse

RUBBER CUSHION

ST	104.9689	
----	----------	--

RUBBER CUSHION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54216



Parent Item: D212-664-101RevC



Parent Item Name: Crosstube Fwd

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased		No		220	Each	201.0000	4.0000			

Clamp(per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	201	
107456	2	
108111	3	
108975	17	
109181	42	
109644	10	
111282	4	
111429	1	
112495	22	
112919	25	
113281	25	
113282	30	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54216



Parent Item: D212-664-101RevC



Parent Item Name: Crosstube Fwd

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2893-1RevB		Manufactured	No			220	Each	72.0000	2.0000			

2.75 Support

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

25657

72

47109

6

47637

2

51775

16

53125

19

53340

19

10

D3428-1RevA



Manufactured

No

240

Each

11.0000 1.0000

Placard

Warehouse

Location

Main Warehouse

ST096

11

50790

11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54216



Parent Item: D212-664-101RevC



Parent Item Name: Crosstube Fwd

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN6-35A



Purchased

No

240

Each

58.0000

4.0000



BOLT

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

Loc Qty

Loc Code

58

112314

112805

38

20

240

Each

123.0000 4.0000



AN6-36A



Purchased

No

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

Loc Qty

Loc Code

423

109632

110382

112314

113121

1

2

70

50

Scanned

Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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• Work Order ID: 54216



Parent Item: D212-664-101RevC



Parent Item Name: Crosstube Fwd

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments: IPP RevH: as per ECN09-696 09.11.19 DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6		Purchased		No		240	Each	524.0000	6.0000			

Nut

Warehouse

Location

Main Warehouse

ST

524

105077

110002

111548

111578

112492

22

5

8

400

89

240

Each

847.0000

18.0000

AN960JD616



Washer

Purchased

No

Warehouse

Location

Main Warehouse

ST

847

112314

112828

113149

47

500

300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

List Lots

December 11, 2009 8:03:34 AM

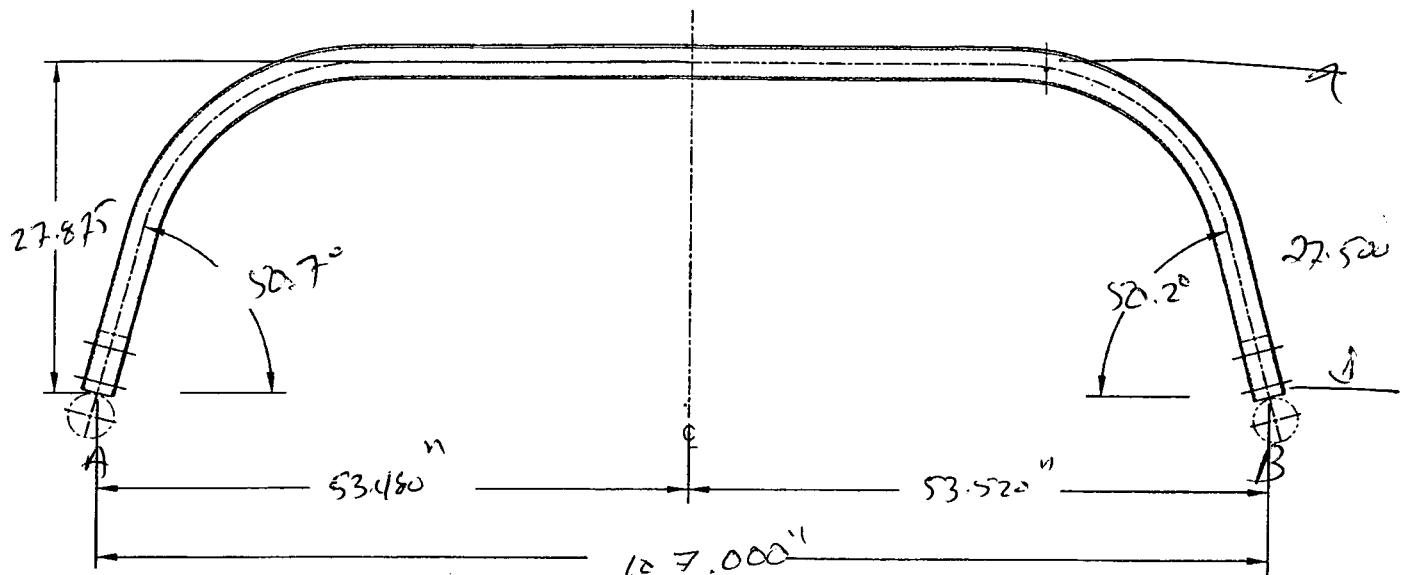
Page 1 of 1

Criteria : Item ID: d6005-128 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID					Lot Code	
D6005-128	Main Warehouse	34686	12/05/09	1.0000		QC21	
Crosstube Material	LG						
	Main Warehouse	38337	12/09/09	3.0000		QC21	
	LG						
				Total: 4.0000			

DART AEROSPACE LTD	Work Order:	54211p
Description: Crosstube High Fwd (205/212/412)	Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

Item	Qty -141	Qty -141B	Part Number	Description
1	X		D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
2		X	D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3	1	1	D6005-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	4	4	MS21920-25	CLAMP (OR MS21920-26)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES .005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF
USING VIBRATING STYLUS
- 7) WEIGHT: D212-664-141 = 33.6 lbs (PER IIN-D212-664)
D212-664-141B = 33.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHEET 1 OF 4

REV. D

DATE 09.09.30

100-100

WORK

NO. 05426

100-100

RELEASED
2009-10-29

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF # ADD TOLERANCES (ZN B4-3, C6-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PP	DRAWING NO.	REV. D
MFG. APPR.	MM	D212-664-141	SHEET 1 OF 4
APPROVED	PP	TITLE	SCALE
DE APPR.	MM	XTUBE ASSY (205/212/412 HI FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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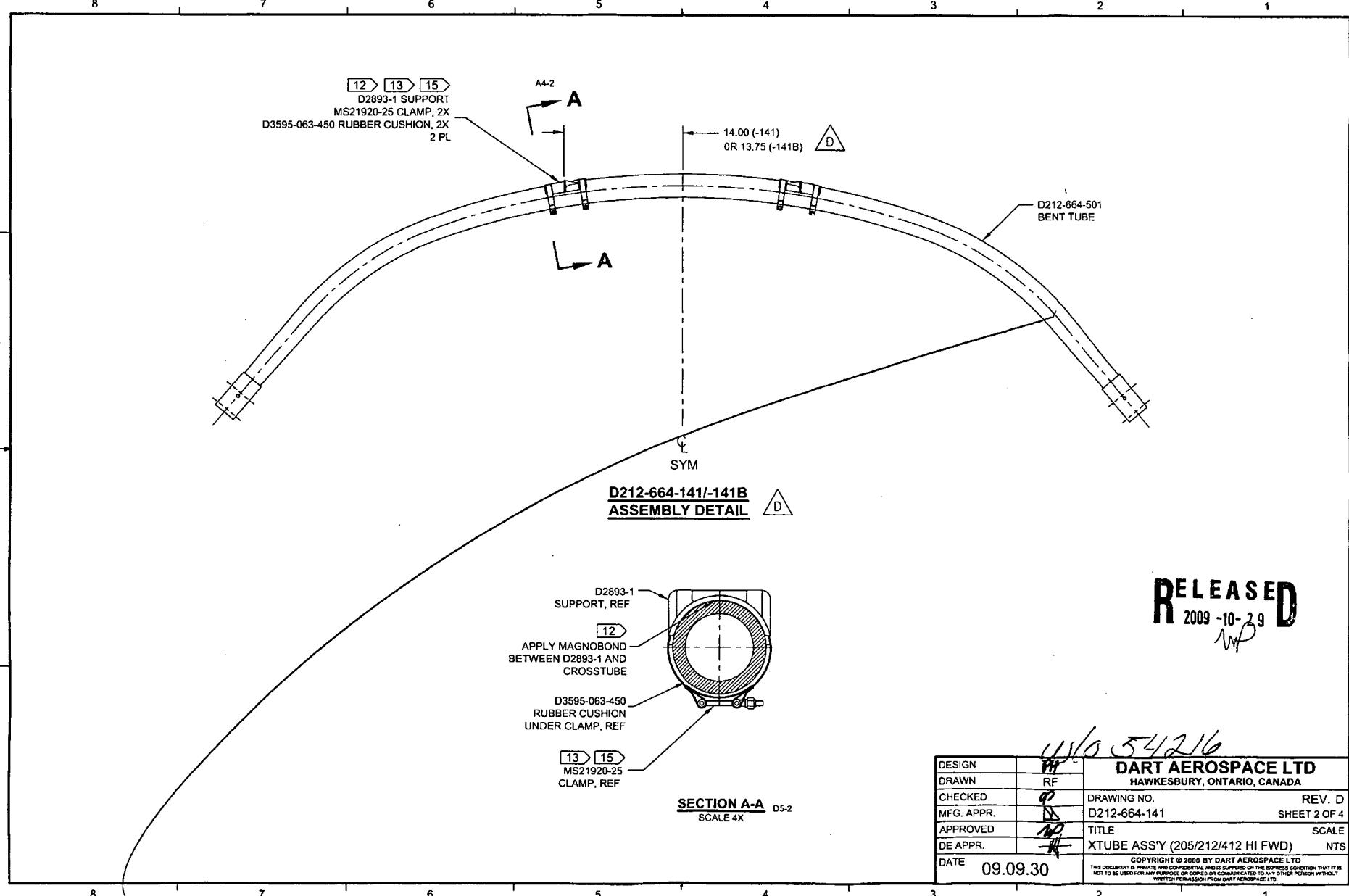
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



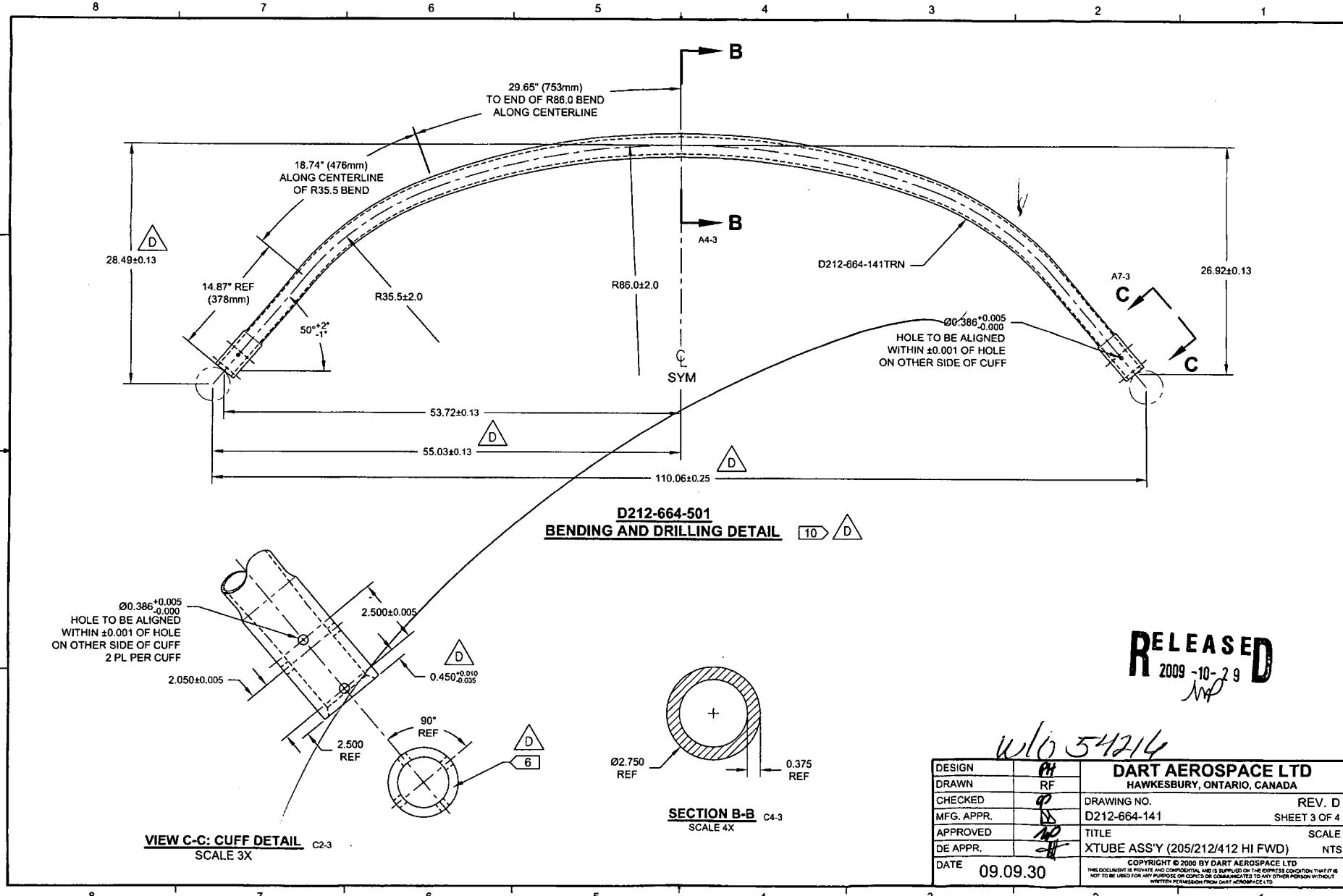
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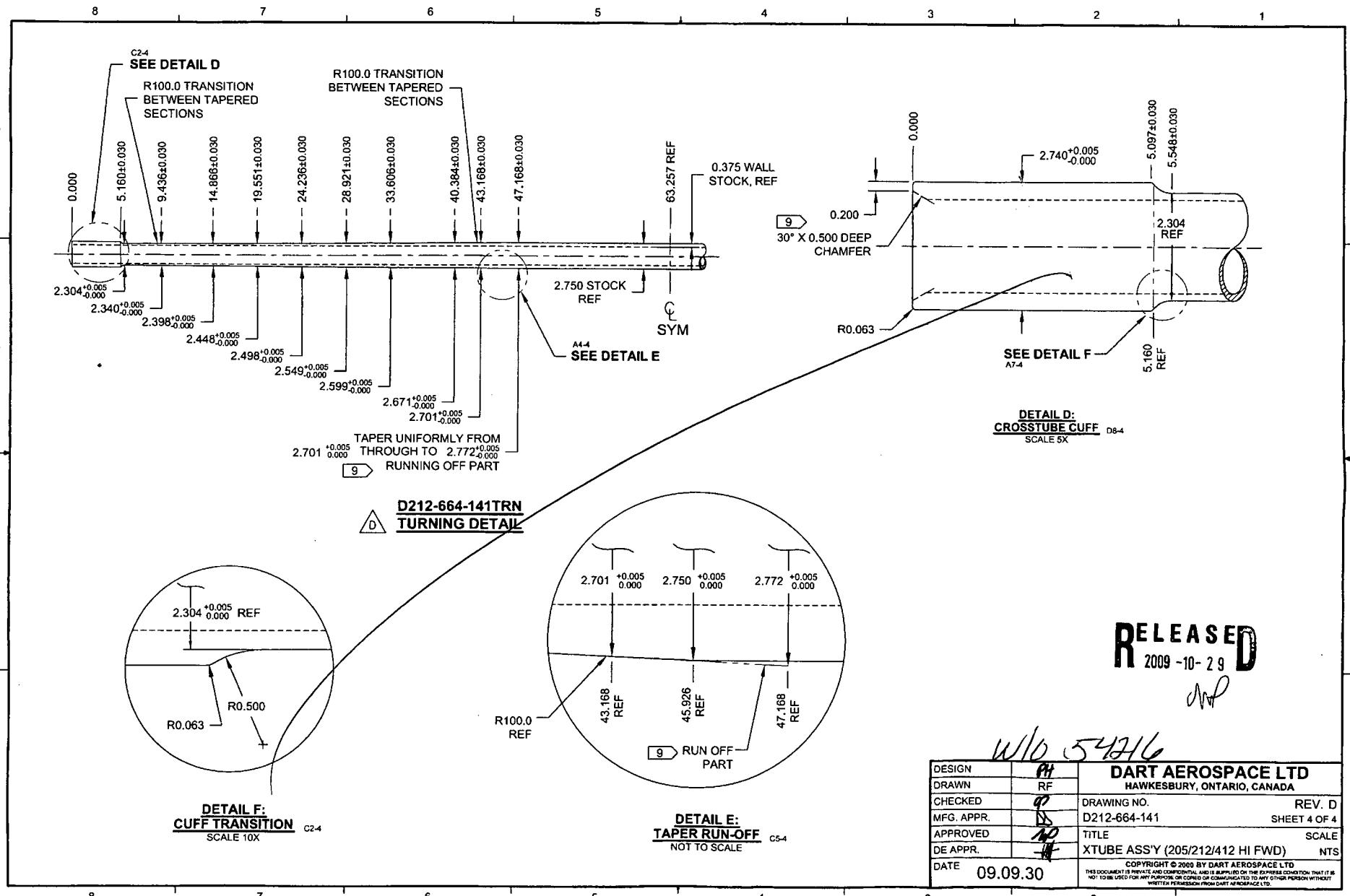
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DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	DS	D212-664-141	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	XTUBE ASSY' (205/12/412 HI FWDF) NTS	
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